

Date: Friday, 06/07/2007 9:49:01 AM  
 User: Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: END CAP
Job Number	: 33239		
Estimate Number	: 11877		
P.O. Number	: <i>N/A</i>	Part Number	: D2208
This Issue	: 06/07/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2208 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 27/06/2007 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	:	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 04/07/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	20 Um: Each
Comment	: Est A 01.03.08 New Issue		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.1531 sf(s)/Unit Total : 3.0618 sf(s)

6061-T6 .063 Sheet  
 5052-H32 or 6061-T6 - .063" Thick  
 Batch *M19326* *IB 07-07-09*

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR

Shear blanks 5.100" x 4.100"

*N/A* *En 07/07/09*

20

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machining as per folio FA 032

Deburr

*water Jet*

*Dwg Rev: C*

*Prog Rev: C*

*IB 0707-09*

*Phd last sheet*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*IB 07-07-09*

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*En 07/07/09* X20

Date: Friday, 06/07/2007 9:49:01 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 33239

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST 19 PC 7/7/09 (20)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20) 07/07/09

Job Completion



CL 07/07/09

Wednesday, 6/27/2007 3:25:59 PM  
Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : END CAP
Job Number : 33239	
Estimate Number : 11877	
P.O. Number :	Part Number : D2208
This Issue : 6/27/2007 S.O. No. :	Drawing Number : D2208 REV <i>BC PRELIM</i>
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : <i>BC PRELIM</i>
Previous Run :	Material :
Written By :	Due Date : 7/4/2007 Qty: 20 Um: Each
Checked & Approved By : <i>07.06.28</i>	
Comment : Est A 01:03.08 New Issue	

Additional Product :

**POSITIVE RECALL**

EFFECTIVE *07-06-28* AUTH *[Signature]*  
RELEASED *07-06-28* DATE *12*

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S063	6061-T6 .063 Sheet
-----	-------------	--------------------

Comment: Qty.: 0.1531 sf(s)/Unit Total :  
6061-T6 .063 Sheet  
5052-H32 or 6061-T6 - .063" Thick  
Batch *M100285*

*Changed  
prog-1/2ai  
ready to RUN.*

2.0	SHEAR
-----	-------

Comment: SHEAR  
Shear blanks: 5.100" x 4.100"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------

Comment: HAAS CNC VERTICAL MACHINING #1  
Machine as per folio FA 032  
Deburr *→ SAB*

*07/07/03 (20)*

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC8	SECOND CHECK
-----	-----	--------------

Comment: SECOND CHECK

*En 07/06/29*

6.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------


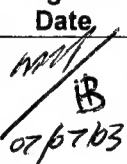
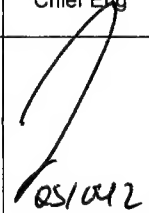
Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *54/LV12*

*07/7/04 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/07/03	#20 water set	one part scrap - water set cut inside the part leaving a small groove in the part ex. part marked	 05/04/02	Scrap will destroy and Re machine on the water set.	 07/07/03	Er 07/07/03	 05/04/02	Er 07/07/03

NOTE: Date & initial all entries

Date: Wednesday, 6/27/2007 3:25:59 PM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: END CAP

Job Number: 33239

Part Number: D2208

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



**POSITIVE RECALL**

EFFECTIVE

AUTH

RELEASED

DATE

*[Signature]* *[Signature]*

→

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

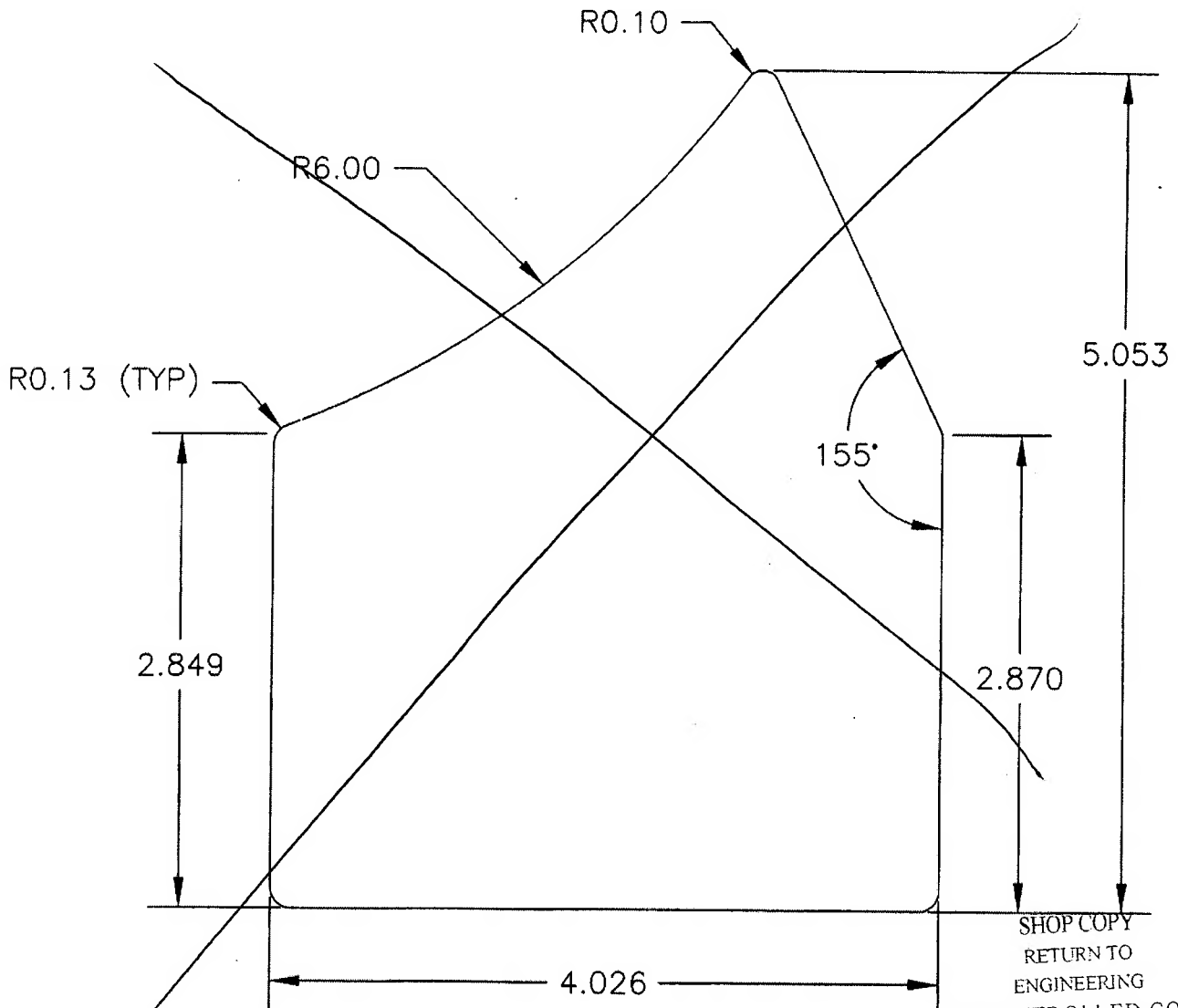
**NOTE:** Date & initial all entries





DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2208	REV. B SHEET 1 OF 1
DATE 01.02.22		TITLE END CAP	SCALE 1:1
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	

RELEASED  
01.02.27 *[Signature]*



MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6  
(QQ-A-250/11) ALUMINUM 0.063 THICK

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33239

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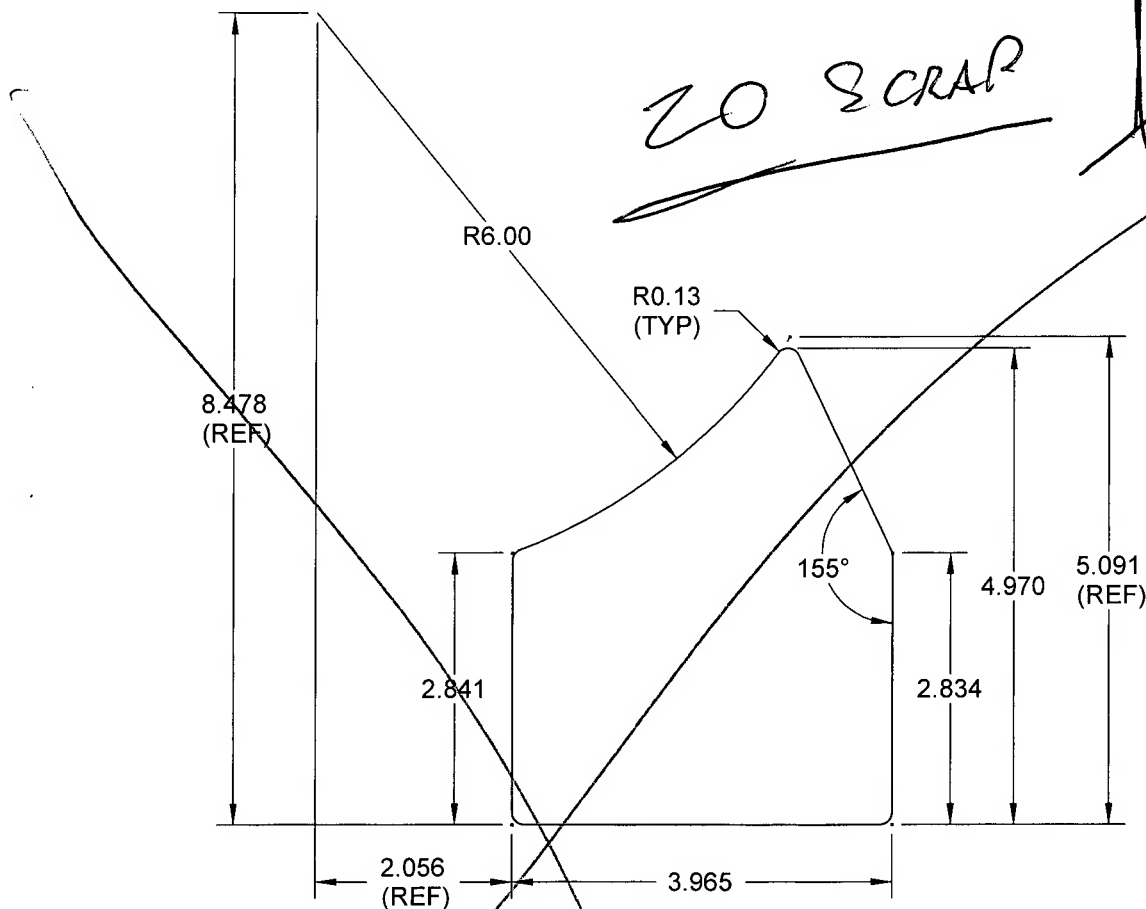
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**PRELIMINARY ISSUE**

07.06.28

DESIGN JF	DRAWN BY JF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED JF	APPROVED	DRAWING NO. <b>D2208</b>	REV. C SHEET 1 OF 1
DATE <b>07.06.28</b>	TITLE <b>END CAP</b>		SCALE 1:2
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	
C	07.06.28	REDESIGN	



**D2208 END CAP**

**NOTES:**

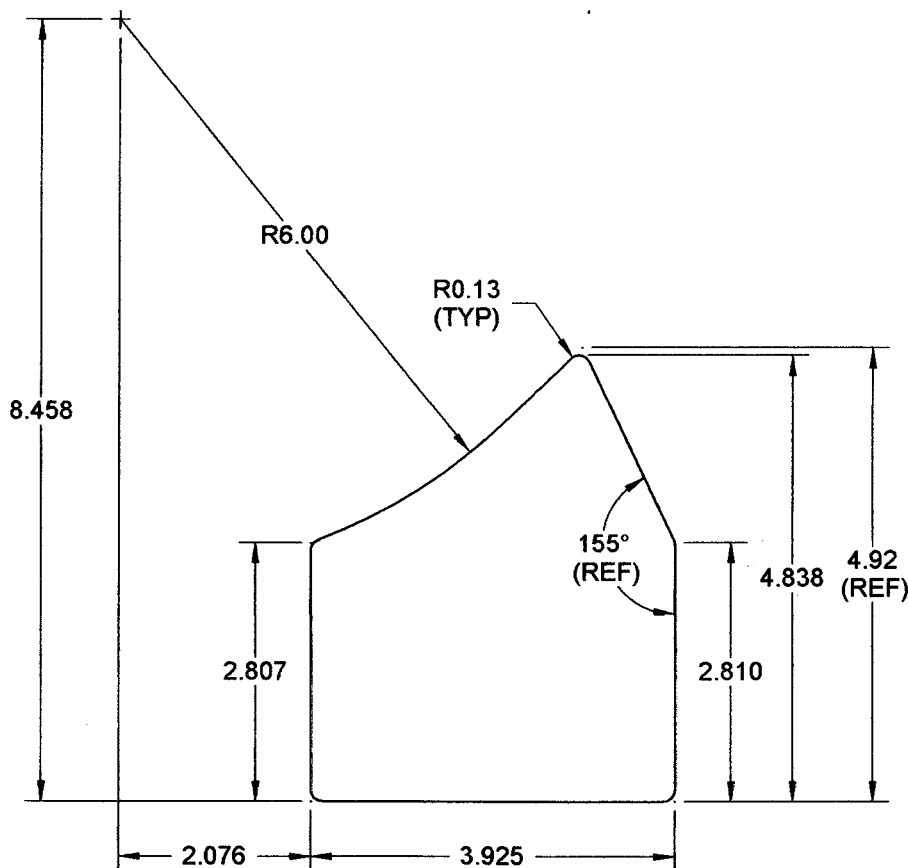
- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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# PRELIMINARY ISSUE

DESIGN	DRAWN BY	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. <b>D2208</b>	REV. C SHEET 1 OF 1
DATE <b>07.07.05</b>	TITLE <b>END CAP</b> SCALE 1:2		
REV	DATE	DESCRIPTION	
A	94.09.01	NEW ISSUE	
B	01.02.22	REDRAWN	
C	07.07.05	REDESIGN	



## D2208 END CAP

### NOTES:

- 1) MATERIAL: 5052-32 ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/8 OR AMS 4016 (REF. DART SPEC. M5052H32S.063) OR 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.063 THICK) PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/07/09	#2.0	Remove step 2.0 <del>add</del> is now cut on water jet	Er	07/07/09			
	#3.0	change from HAAS to water jet and ADD deburr step					
07							

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries